

Date: Thursday, 16/10/2008 10:45:21 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 42630B  
 Estimate Number : 10207  
 P.O. Number :  
 This Issue : 16/10/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LARGE FAB ASSY  
 Previous Run : 42628B  
 Drawing Name : BASKET LID ASSEMBLY  
 Part Number : D2989043  
 Drawing Number : D2989 REVC  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 11/11/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.10.16  
 Comment : Est Rev:I Removed D2989-041 05-11-03 JLM  
 Est Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 Est Rev:K 08-09-24 plug holes prior to powder coating. DD  
 verified by:EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31821	Hinge
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D3182-1 Hinge <u>B 39336</u> ✓		
		<u>JS 08/11/20</u>
2.0	D34423	Shim
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: ✓ Qty Part number Description Batch 2 D3442-3 Shim <u>B 42718</u>		
		<u>JS 08/11/20</u>
3.0	M304EX07516F	Expanded Metal Flat SS
Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s) Pick: * Qty Part number Description Batch 8sf M304EX0.75-16F Expanded Metal <u>M 100071</u>		
		<u>JS 08/11/19</u>
4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s) ✓ 3/4" x 3/4" x 0.065" wall 304/316 SS tubing. Batch: <u>M 109731</u>		
		<u>JS 08/11/06</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 16/10/2008 10:45:22 AM  
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Drawing Name: BASKET LID ASSEMBLY

Job Number: 42630B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom ✓

2-Drill holes in tubing as D2989-043 per Dwg D2989 ✓

3-Deburr and remove all markings on material ✓

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required ✓

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid ✓

*SL 08/11/20*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PLC 08-11-24*

*08/11/21*

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*5 08/11/21*

8.0

POWDER COATING

POWDER COATING



*M109152*



*(12)*

Comment: POWDER COATING

1- Plug holes in D2989-17 and D2989-2 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*1:50  
400°F  
2:20  
2:40  
400°F  
3:10*

*M-1 08/11/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Job Number: 42630B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

08/11/25 @

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



08-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2989-041	BASKET LID ASSEMBLY
	X	D2989-043	BASKET LID ASSEMBLY
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2	2	D2989-17	STRUT
2		D2989-19	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

**RELEASED**  
08.06.2014

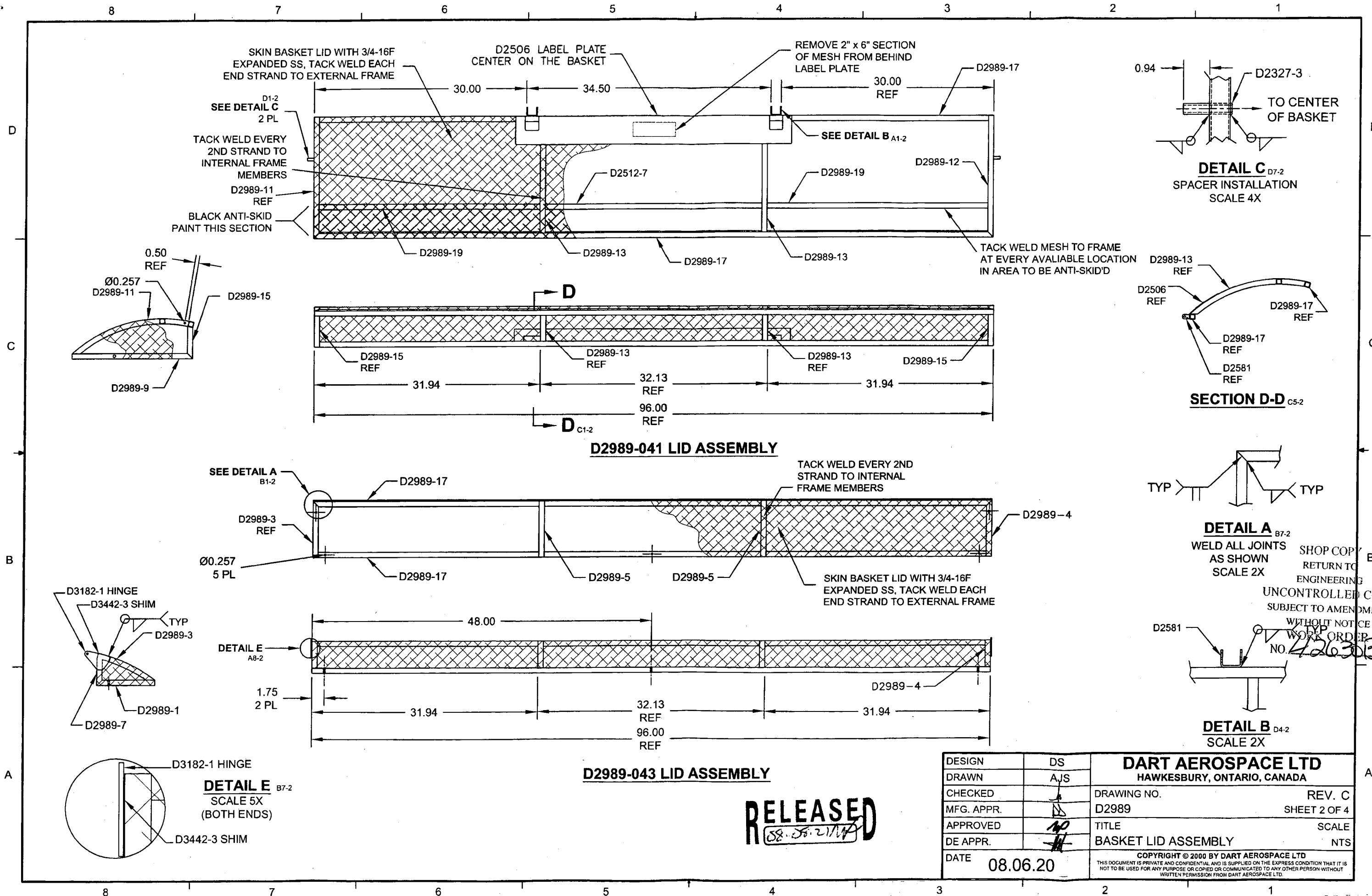
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WORK ORDER  
NO. 42630B



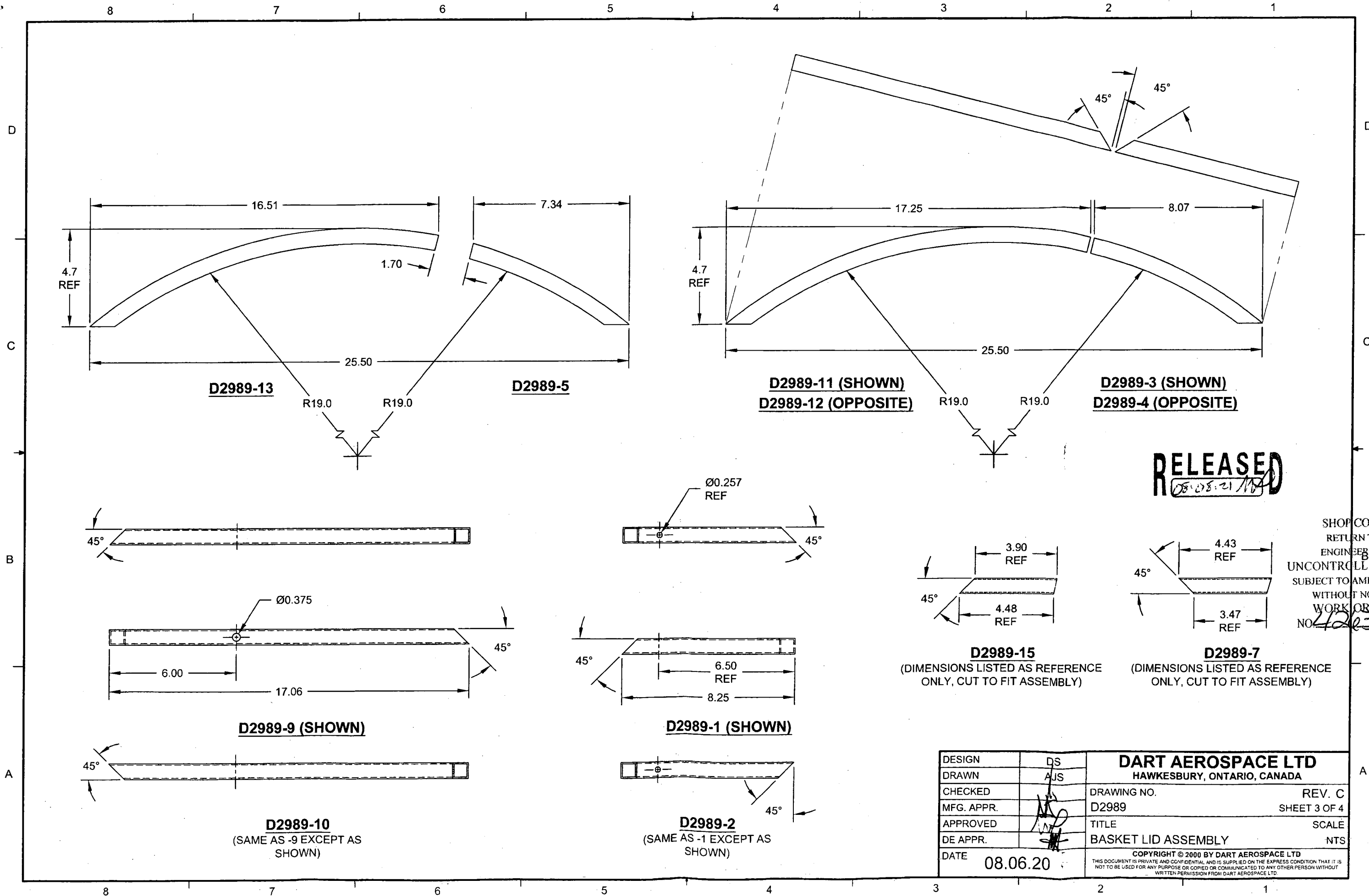
**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065  
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING TRANSFERED TO "B" SIZE FORMAT & CURRENT DRAFTING STANDARD.	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2989	SHEET 1 OF 4
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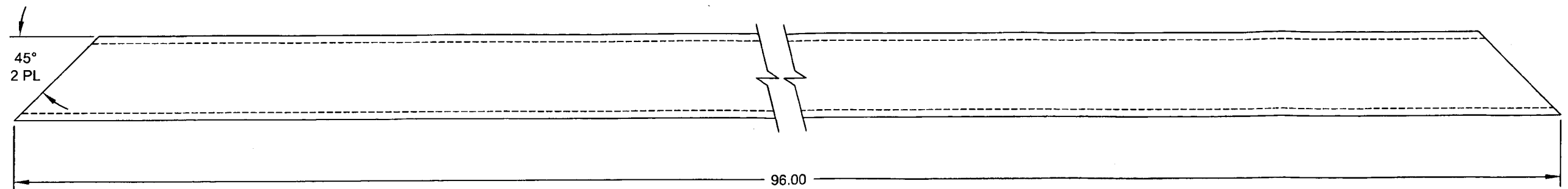
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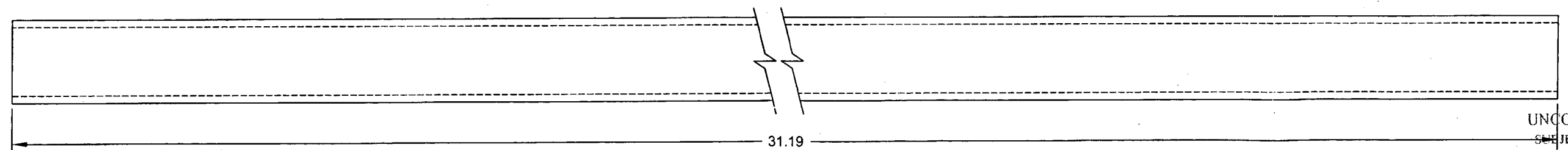
D2989-17 STRUT

C

C

B

B



D2989-19 STRUT

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